DO NOT SCALE

CHANGE NOTICE	LETTER	DESCRIPTION OF CHANGE	CHG. BY	DATE	CHK'D BY
		50-93			

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VANSICKLE INDUSTRIES, INC.
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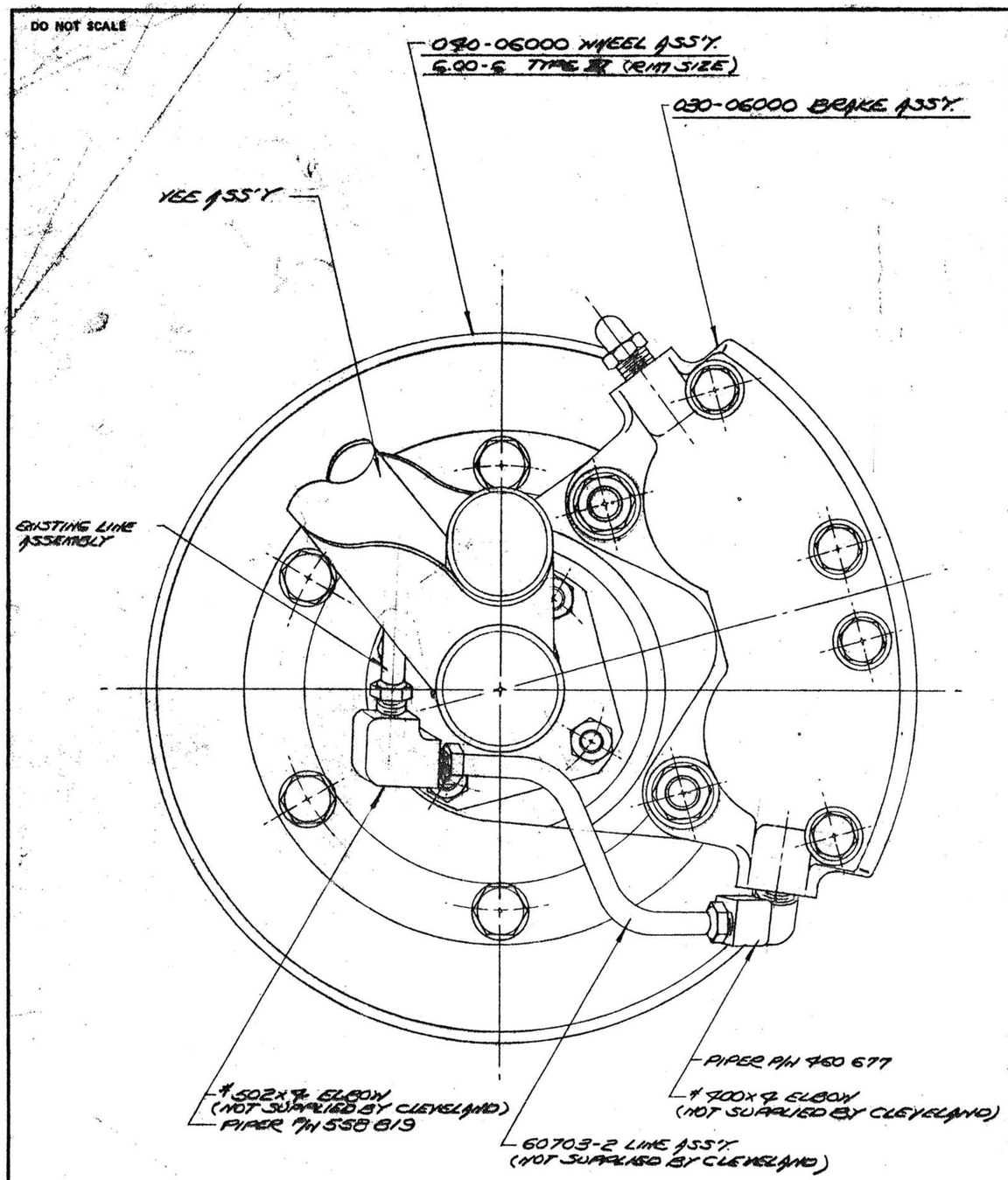

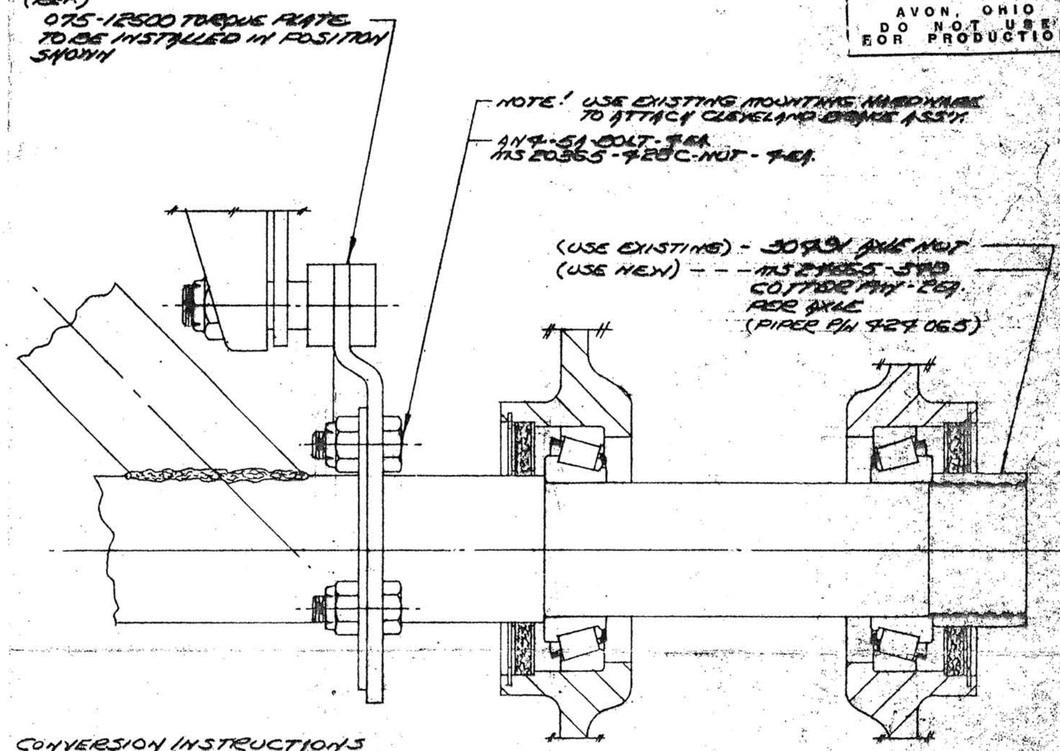

CONVERSION INSTRUCTIONS

1. SECURELY JACK-UP AIRCRAFT AFT-BACK-BRAKE PEDALS.
2. REMOVE EXISTING WHEEL ASS'Y. (#451 760), BRAKE ASS'Y. (#51 702), AND BRAKE BLEEDER FITTING (#51 771)
3. ATTACH 075-12500 TORQUE PLATE ASS'Y. TO LANDING GEAR, USING EXISTING HARDWARE. TORQUE TO 50-70 IN.-LBS.
4. INSTALL 040-06000 WHEEL, TIRE AND TUBE ASS'Y. ON AXLE. SEE LIST FOR CORRECT TIRE SIZE AND PLY RATING. (WHEEL, TIRE & TUBE MUST BE PROPERLY BALANCED)
5. INSTALL AXLE NUT AND TIGHTEN TO ALLOW AND WHEEL SIDE PLAY, YET ALLOWING THE WHEEL TO ROTATE FREELY. SAFETY THE NUT WITH TWO MS24665-343 COTTER PINS AND INSTALL PIPER WHEEL COVER. (27 330-00)
6. REMOVE PA-27 BACKPLATE ASSEMBLIES FROM THE CALIPER
7. SLIDE CALIPER INTO TORQUE PLATE, AND CHECK FOR PROPER ALIGNMENT AND FIT
8. RE-ASSEMBLE PA-27 BACKPLATE ASS'Y.S, AND TORQUE THE (4) AN4-5A BOLTS TO 60 IN.-LBS. + SAFETY WIRE AS REQUIRED
9. ATTACH PIPER SUPPLIED PLUMBING (#502 x 4 ELBOW), (60703-2 LINE ASS'Y.) AND (#400 x 4 ELBOW) AS SHOWN ON DRAWING
10. REMOVE THE BLOCKS FROM THE PEDALS, AND BLEED THE BRAKE SYSTEM.
11. PRESSURIZE AND RELEASE THE BRAKES AND SPIN THE WHEELS. THERE SHOULD BE NO EVIDENCE OF EXCESSIVE PARTS OR BINDING. A SLIGHT AMOUNT OF BINDING COULD BE THE RESULT OF MISALIGNMENT BETWEEN THE BRAKE CYLINDER AND THE RIGID HYDRAULIC INLET LINE
12. APPLICABLE TIRES AND TUBES:
    - 6.00-6, 4 PLY TIRE - - - 6.00-6 TUBE
    - 7.00-6, 6 PLY TIRE - - - 7.00-6 TUBE
    - 8.00-6, 4 PLY TIRE - - - 8.00-6 TUBE
13. LOG BOOK ENTRY:
    MODELS, PA-18-150 + PA-18A-150:
    RECORD THE FOLLOWING INFORMATION,
    "WHEEL AND BRAKE CONVERSION PERFORMED IN ACCORDANCE WITH PIPER SERVICE KIT NO. 761 081"

QTY	QTY	ITEM	PART NO.	DESCRIPTION	MATERIAL & SPEC.	HEAT TREAT & SPEC.	FINISH & SPEC.	WGT.

NEXT ASSEMBLY	QTY	FINAL ASSEMBLY	QTY	PATTERN, CASTING OR BLANK NO.	DRAWN BY	
					CHECKED BY	
					SCALE	

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ZYGLO PER MIL-I-6866 STAMP M ON PART
MAGNAFLUX PER MIL-I-6868 STAMP P ON PART
√ MACHINED SURFACES PER MIL STD 10 UNLESS OTHERWISE NOTED
UNLESS NOTED ALL THREADS PER MIL-S-7742

WORK TO DIMENSIONS – DO NOT SCALE
TOLERANCE FOR .XXX ± .010
TOLERANCE FOR .XX ± .030
TOLERANCE FOR ANGULAR DIMS. ± 1/2°
TOLERANCE FOR FRACTIONAL DIMS. ± .030
BREAK SHARP EDGES .010 UNLESS NOTED. REMOVE ALL BURRS BEFORE PLATING. DRILL PER INSP. PROCEDURE NO. 114.

Cleveland Wheels & Brakes
1180 Avon Center Road, Avon, Ohio 44011
a division of VanSickle Industries, Inc.
"the brake people"

NAME: CLEVELAND WHEEL & BRAKE INSTALLATION - PA-18-150
50-93